Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2572
Job Sheet 179309

Part No: D2572 **Job Qty:** 8 ea
Part Name: Saddle, Fwd, In

Part Weight: 0 lbs **Status:** Scheduled **Priority:** Medium
Job Created: 6/16/18 **Job Tracking No:**
Due Date: ~~7/6/18~~ July 25 **Created By:** Marie Lajeunesse
Type: Stock **Description:**

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup hrs	Standard Run Hrs	Workcenter/Supplier Workcenter / Supplier	Lead Time	Sign-off
90	**Start up Operation**	8 Ea		7/6/18	0.00	0.00	Start Up Machining		SBL 18/07/17
100	**CNC Vertical Machining**	8 pcs		7/6/18	0.62	12.90	HAAS 1		SBL
110	**Mill Conv**	8 pcs		7/6/18	0.00	1.33	Mill Conv 1		SBL
120	**QC**	8 pcs		7/6/18	0.00	0.00	QC2		VHF 18/07/17
130	**QC**	8 pcs		7/6/18	0.00	0.00	QC8		[illegible] 18/07/21
140	**HandFinish**	8 pcs		7/6/18	0.00	0.33	HandFinish1		SA 18-07-23
150	**Powdercoat**	8 pcs		7/6/18	0.00	0.30	Powdercoat1		[illegible] 18-7-23
160	**QC**	8 pcs		7/6/18	0.00	0.00	QC3		D 18-07-23
170	**Packaging**	8 pcs		7/6/18	0.00	0.00	Packaging3 SK397		
180	**QC21-SA**	8 Ea		7/6/18	0.00	0.00	QC21		JUL 24 2018

Part Op **100** - Program Batch No: S092608 Double check by: SF 1-Machine Step No 1 per Folio FA051 and inspect per
Descriptions: attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp
110 - Machine keyway as per dwg D2571 & D2572
150 - START TIME: 3:20 FINISH TIME: 3:50. OVT: 3:20 M138839 DAS 21 9-89 JUL 24 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	8 Ea (1 ea)	90-Start up Operation	S059502 ↳ S092606

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-005	8	54	0

Part Specifications

Spec No	Description	Target/Tolerance		Limits	Type	Special Comments
1	Saddle, Fwd Inboard	0.438Inches	+ 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Inboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Inboard	3.495Inches	+ 0.010 - 0.000	3.505 3.495		
4	Saddle, Fwd Inboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No.

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Suspected Unapproved	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Cross tube	☐	Water Jet	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐
Large Fab	☐	Composite	☐	Supplier	☐

Engineering	☐		
Quality	☐		
Other	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
Description Work Order Deviation		**Disposition**	

Completed By

Lead hand / Supervisor Approval Verification

QC / QA Coordinator Approval

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/17/18

DART AEROSPACE

Container No: S092608

Part: D2572

Job No: 179309

Serial No/Batch: S092608

Revision:

Inspector:

Exp Date:

Instructions:

Root Cause

Environment	☐	☐	No Re-verfication
Design	☐	☐	Operator
Doc/Data	☐	☐	Offset/Setup
Equip/Tooling	☐	☐	Supplier
Handling/Pre	☐	☐	Training
Material	☐	☐	Use for Testing
Internal Transport	☐	☐	Poor Information
Tribal Knowledge	☐	☐	Rushing
LOA	☐	☐	Product Improvement
Substation	☐	☐	Process Improvement
Past Expiry Date	☐	☐	Manufacturing Process
Misidentified	☐	☐	Past Due

☐ P	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Positioned Wrong
☐ B	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Outside Dimensions
☐ C	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Over/Under tolerance
☐ C				☐ Part Incorrect
☐ C				☐ Part Lost/Missing
☐ C				☐ Part Moved
☐ C				☐ Drawing
				☐ Finish
				☐ Misread
				☐ Turning Sequence

☐ OTHER :

5	Saddle, Fwd Inboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Fwd Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Fwd Inboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Fwd Inboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Fwd Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Fwd Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Fwd Inboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Fwd Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Fwd Inboard	1.490Inches	+ 0.010 - 0.000	1.500 1.490
14	Saddle, Fwd Inboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Fwd Inboard	3.869Inches	+ 0.010 - 0.000	3.879 3.869
16	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Inboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Fwd Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Inboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Fwd Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

DART AEROSPACE LTD	Work Order:	179 309
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		,438 -	0.435	0.438	0.438		
B	1.745	1.755		1.750 -	1.750	0.438	0.438		
C	3.495	3.505		3.500 -	3.500	3.500	3.500		
D	1.745	1.755		1.750 -	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.003	8.002		
F	0.490	0.510		,498	0.497	0.499	0.499		
G	0.257	0.262		,257	,257	,257	,257		
H	0.375	0.380		,375	,375	,375	,375		
I	0.490	0.510		,500	,498	,498	0.4975		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		,567	,566	,566	0.5645		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.875	3.874		
P	0.115	0.135		,125	,130	,133	0.125		
Q	0.115	0.135		,124	,124	,124	,124		
R	0.240	0.260		,251	,251	,250	,250		
S	0.115	0.135		,123	,125	,125	0.125		
T	0.178	0.198		,188	,188	,188	,188		
U	2.940	2.980		2.961	2.960	2.960	2.960		
V	0.230	0.250		,238	,239	,239	0.237		
W	0.115	0.135		,130	,135	0.135	0.135		
X	0.307	0.312		,311	0.312	0.312	0.310		
Y	0.760	0.765		.760 -	0.760	0.760	0.760		
Z	0.352	0.372		,366	,366	0.366	0.363		
AA	0.470	0.530		,500	,500	,500	0.500		
AB	0.615	0.635		,624	,622	,622	0.627		
AC	0.053	0.073		,061	,057	,057	0.058		
AD	0.240	0.260		,248	,249	,248	0.248		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		,128	0.130	0.135	0.135		
AG	0.240	0.280		,250	,250	,250	0.250		
AH	0.240	0.260		,246	,247	,247	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject				DAS					

Measured by:	57
Date:	9-89 18/07/17

Audited by	
Date:	18/07/24

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order:	179 309
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#5	#6	#7	#8	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.002	8.004	8.003		
F	0.490	0.510		0.499	0.499	0.504	0.500		
G	0.257	0.262		.257	.257	0.257	0.257		
H	0.375	0.380		.375	0.375	0.375	0.375		
I	0.490	0.510		0.4975	0.4985	0.506	0.502		
J	1.174	1.184		1.179	1.179	1.197	1.179		
K	0.558	0.578		0.568	0.5675	0.572	0.574		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.135	0.130	0.135	0.135		
Q	0.115	0.135		.125	.125	0.125	0.125		
R	0.240	0.260		.250	.250	0.250	0.25		
S	0.115	0.135		0.132	0.125	0.127	0.126		
T	0.178	0.198		.188	.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.235	0.238	0.235	0.237		
W	0.115	0.135		0.133	0.133	0.130	0.120		
X	0.307	0.312		0.310	0.311	0.310	.312		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.366	0.366	0.366	0.366		
AA	0.470	0.530		.500	.500	0.500	0.500		
AB	0.615	0.635		0.623	0.623	0.628	0.628		
AC	0.053	0.073		0.058	0.058	0.058	0.058		
AD	0.240	0.260		0.245	0.246	0.248	0.248		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.130	0.135	0.135	0.135		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.249	0.250	0.250	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	
Date:	18/07/17

Audited by	
Date:	18/07/24

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	